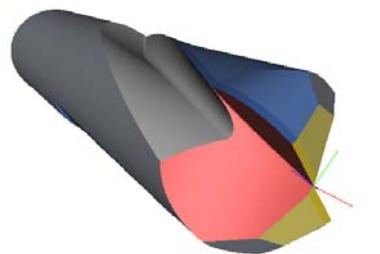


Flatface Radius Endmill Ø25/15 Z2 R10

A01-110

The flatface radius endmill type A01-110 in Quinto5 allows to produce and resharpen radius endmills with tangential begining of the radius at OD and given enddiameter. Optionally the radius can be defined tangential to the end. Straight or radial gashings are possible and adjustable along the radius. Wheels and grinding processes of flute, gashing, end and OD are similar to common standard tools. The below cycle time is calculated for production.



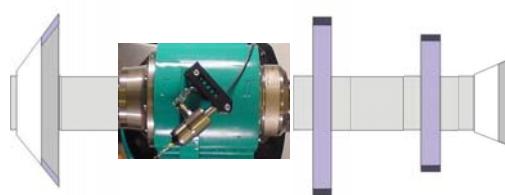
1. Cycletime for Production

Workpiece: Ø25 mm, Z 2, L 45 mm Material CARBIDE											
Operations	Probe	Flute 1	Gashing	O.D.3	O.D.2	O.D.1	End 2	End 1	Radius 2	Radius 1	backclr.
Feed [mm/Min]	2000	60	80	100	170	220	80	100	120	120	100
Power [kW]		3	2	1	1	2	1	1	4	3	2
Cutting speed [m/s]		20	22	22	22	22	22	22	22	22	22
Used wheels		1	2	2	3	3	4	4	4	4	4
Grinding time [s]	20	123	57	286	184	147	42	37	73	73	58
Total cycle time	18 Min 20										

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	1A1 Ø100 D64
4	11V9 Ø75 D64



2

1

3 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
 Control: Fanuc 31i Software: Quinto 5

Accessories:

Responsible engineer: OP. 7.2.12

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